

Date: Monday, 1/16/2006 4:13:52 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LOW GEAR SKIDTUBE ASSEMBLY 206 A/B
Job Number : 25504A	
Estimate Number : 11972	
P.O. Number : N/A	Part Number : D206642141
This Issue : 1/16/2006 S.O. No. : N/A	Drawing Number : D2650 REV D1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : D1
Previous Run : 25503A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 2/23/2006 Qty: 1 Um: Each
Checked & Approved By : <u>SEE ABOVE USER & DATE</u>	
Comment : Est Rev:H 05.10.11 ECN 847 & 901; Add Tow Ring and GHW Kit; CHG004 KJ/CP/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2620	Bent 206 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD B24497 DP 06-2-7 ①

2.0	D32861	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler B24206 BE 06-2-8 ①

3.0	D2647	Cap
-----	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap B20535 BE 06-02-07 ①

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube DP 06-2-7 ①

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650 DP 06-2-7 ①

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Number:



Machine Or Operation:

Description:

Qty Part Number Description Batch
A/R Aluminum Rod

M15855 / M19100 BE 06-02-07 (1)

4-Grind weld flush to cap on top surface only.

BE 06-02-07 (1)

5-Cut Aft end as per dwg 2650 from front of tube and Deburr.

DP06-2-8 (1)

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

DP06-2-8 (1)

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

DP06-2-8 (1)

8-Drill pilot holes using Dt 8166 (A,B & C).

DP06-2-8 (1)

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

BE 06-02-10 (1)

10- Drill D3286-1 doubler rivet holes in tube using #40 drill, spot drilling doubler at the same time.

BE 06-02-10 (1)

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

BE 06-02-10 (1)

12-Remove and Deburr D3286-1 doubler

BE 06-02-10 (1)

13-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

BE 06-02-10 (1)

14-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

BE 06-02-10 (1)

15-Remove indexing edge using DT8741 as per Dwg D2650

BE 06-02-10 (1)

16-C'sink GHW rivet holes as per Dwg D2650

BE 06-02-10 (1)

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes as per Dwg D2650

BE 06-02-15 (1)

2-Drill pilot holes using DT8028-1, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

BE 06-02-15 (1)

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Job Number: 25504A

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Deburr tube and blow out chips from inside the tube :

BE 06-02-15 (1)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BE 06-02-17 (1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 06-2-17 (1)

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-1 Drilling Detail (without cutting fluid)

BE 06-02-17 (1)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

BE 06-02-17 (1)

3-Deburr and blow out all chips from inside the tube

BE 06-02-17 (1)

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

DP 06-2-17 (1)

11.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

M19185 BE 06-02-17 (1)

12.0

D26543

206 I-Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2654-3

Web

B24581 BE 06-02-17 (1)

W/O:		WORK ORDER CHANGES					
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Job Number: 25504A

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

BE 06-02-17 (1)

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 06-02-17 Time: 10:00

Finish Date: 06-02-20 Time: 7:00

BE 06-02-17 (1)
BE 06-02-20 (1)

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expire date:

M 19597
06-06-18

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total: 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 D2649

Crossbolt spacer

B 24200 BE 06-02-20 (1)

16.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3

Spacer

B 24711 BE 06-02-21 (1)

17.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M 18839 BE 06-02-20 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 25504A

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Grind welds flush as per Dwg D2650.

BE 06-02-21 (1)

3-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R SS Rod *N/used*

BE 06-02-21

4-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

18.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets *M18548 BE 06-02-24 (1)*

19.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets *M7808 BE 06-02-24 (1)*

20.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate *B21103 BE 06-02-24 (1)*

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

BE 06-02-24 (1)

22.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore work to Current Step. Inspect for foreign objects as per QSI 024

J 06-03-01
AD 06/03/02

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 25504A

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

9. m 06-03-16

(1)

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/03/16

(1)

25.0

D26483

Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2648-3

Wearpad

B 2443

(1)

26.0

D265611

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-113

Wearshoe

B 20357

(1)

PTO

27.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

B 20532

(1)

28.0

D265631

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-31

Wearshoe

B 20754

(1)

9. m 06-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-16	26	-13 wear plate. -11 next the right one. permanent change.					 06-03-16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25504A

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B 24417

(1)

30.0

ALS41032130

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

42 ALS4-1032-130 Inserts

M 18293

or (see QSI 017)

(42)

31.0

AN960JD10L

Washer



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

42 AN960JD10L

Washer

M 19185

(42)

32.0

MS27039108

Screw



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

42 MS27039-1-08

Screw

M 16941

(42)

33.0

D26511

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2651-1

Plugs

B 26010

a.m 06-03-16

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 25504A

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D26513

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
16 D2651-3 O-Rings B 03491

⑫

35.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
.1 MS27039-4-06 Screw M 15194

①

36.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN960JD416 Washer M 1151

①

37.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 M19597
Sikaflex expire date: 06-18-06 a.m. 06-03-16

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153.

Q.m 06-03-16

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect for foreign objects as per QSI 024

md

06 03 17

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 25504A

Part Number: D206642141

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B 22587

(1)

40.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw M 16941

(2)

41.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer M 19185

(2)

A . m 06-03-16

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M 17597

Sikaflex expire date: 06-18-06

A . m 06-03-16

(1)

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: 100081

A . m 06-03-16

43.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

44.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

①
06/03/23

Job Completion



u 06-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2650	REV. D SHEET 1 OF 5
DATE 04.05.17		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	

RELEASED
04.06.22 *H*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES


- 1) WELD PER DART QSI 004
- 2) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 3) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 4) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 5) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 6) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

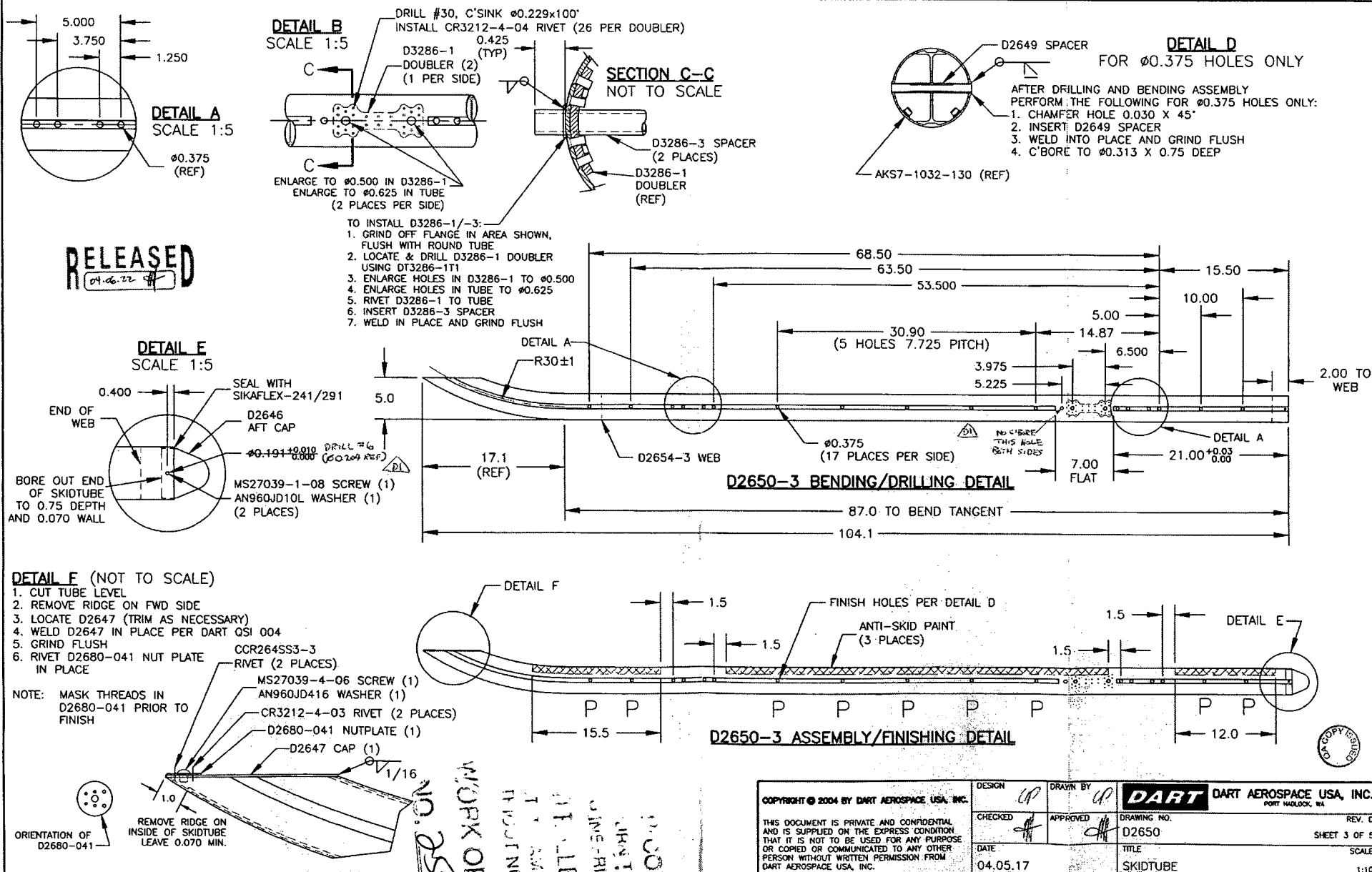
D1109# CHG. 09 REMOVE CORE FROM HOLE, CAP SCREW, HOLE SIZE

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITH 10UT NOTICE
WORK ORDER
NO. 25504A

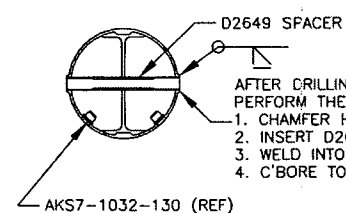
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	CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2650
	DATE 04.05.17	TITLE SKIDTUBE	



16
NO. 25504A
WORK ORDER
THAT AMENDMENT
THAT NOTICE
ATTACHED COPY
CONCERNING
UNIT'S
COPY



DETAIL D
FOR Ø0.375 HOLES ONLY

— AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313 X 0.75 DEEP



ORIENTATION OF
D2680-041

REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

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SCALE

1:10

